

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018393**Date Inspected:** 18-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY- 3

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07403.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The members are identified as OBG Longitudinal diaphragm weld Components. Total number of welds UT Tested: 14 No's. The weld designations are review as follows:

1. LD3041-001-037,039,031,033,026,024.
2. LD3043-001-040,042,035,033,024,026,017,019.

This QA Inspector Randomly observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Flux Cored Arc Welding (FCAW) of weld joint LD3040-001-082. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4b-F.

FCAW of weld joint SEG3019AZ-005. Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Zhu jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2231-TC- U4b-F.

FCAW of weld joint FB3286-001-346. Welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Zhu jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC- U4c-F.

FCAW of weld joint SEG3019K-014. Welder is identified as 067036. ZPMC Quality Control (QC) is identified as Mr. Zhu jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2231-TC- U5-F.

BAY- 2

FCAW of weld joint FB3343-001-191. Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Xu jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4c-F.

FCAW of weld joint FB3343-001-174. Welder is identified as 066421. ZPMC Quality Control (QC) is identified as Mr. Xu jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4c-F.

FCAW of weld joint FB3343-001-214. Welder is identified as 066852. ZPMC Quality Control (QC) is identified as Mr. Xu jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4c-F.

FCAW of weld joint SEG3019K-080. Welder is identified as 058245. ZPMC Quality Control (QC) is identified as Mr. Xu jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC- U5-F.

This QA Inspector performed photo documentation on Lift 14 Hinge plates are identified as FB3286A, FB3273A, FB3272A, FB3328B, FB3327A,FB3343A,SA3325A,SA3324A,SA3409A and SA3410A located in sub assembly bay 2 and 3. These photos has been sent to QA lead Inspector and Structural Material Representative (SMR) by mail.

During random in process inspection of OBG member identified as SEG3019K this QA observed a cracked tack welds on weld joint identified as SEG3019K-047. This QA marked the cracked tacks and informed ZPMC Quality Control (QC) indentified as Mr. Xu jie of this issue. Mr. Xu jie informed this QA that the cracked tacks would be corrected in a manner compliant with the contract documents. Refer the attached photos for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
